

Date: Thursday, 6/29/2006 10:54:13 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 27776		
Estimate Number	: 12470		
P.O. Number	: N/A	Part Number	: D3492047
This Issue	: 6/29/2006 S.O. No. : N/A	Drawing Number	: D3492 REV PREL
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: PREL
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 7/6/2006
Checked & Approved By	: <u>06/06/29</u>	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 06-06-20 JLM		

Additional Product

Job Number:



Seq. #

Machine Or Operation:

Description :

1.0

M6061T6R0500

6061-T6 Round Bar .500"



Comment: Qty.: 0.0656 f(s)/Unit Total: 0.6563 f(s)

6061-T6 Round Bar .500"

(M6061T6R0500)

Batch: M 16991/305 M101421/7PCS J.F. 06/06/29 10

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA644 & Dwg D3492

Dwg Rev: B

Folio Rev: OPERATOR

J.F. 06/06/29 10

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/06/29 10

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Ep 06/06/29 x 10

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

J.F. 06/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DS Date: 06/08/2012

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/29/2006 10:54:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 27776

Part Number: D3492047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD

06:07:05

(10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

SC 06/07/19

DL

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 07/20

(10)

9.0

NAS1611007

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-007 O-RING

M101332

DL 06/07/20

(10)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube
A/R 55-O'Ring Lube Batch: M101223

DL 06/07/20

(10)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL

06 07 20

(10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 303

PT 06.07.20

EP 15

DL

06/07/20

(10)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Dale,
Return to

06.07.20

PH. for Confirmation

06-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

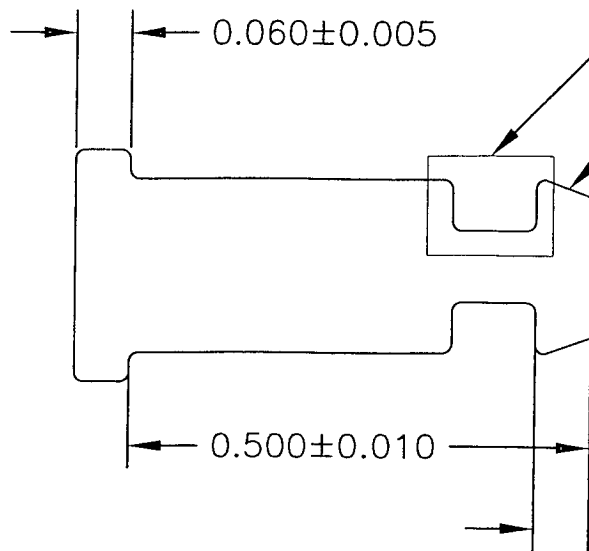
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

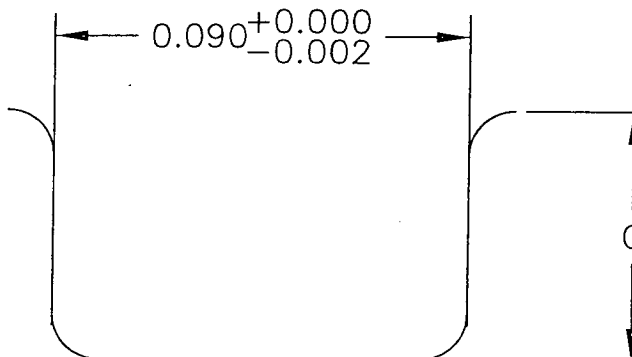
QA: N/C Closed: _____ Date: _____



SEE WITH TABLE 2

-045 PLUG ASSEMBLY

Handwritten notes:
 49 Done for 5X



GROOVE DETAIL

ASSEMBLY PARTS LIST

Description	
PLUG ASSEMBLY	
PLUG ASSEMBLY	
PLUG ASSEMBLY	
PLUG ASSEMBLY	
PLUG	
PLUG	
PLUG	
PLUG	
O-RING	SHOP COPY
O-RING	RETURN TO
O-RING	ENGINEERING
O-RING	UNCONTROLLED COPY
O-RING	SUBJECT TO AMENDMENT
	WITHOUT NOTICE

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C
D3492-1	0.625	0.394	0.055
D3492-3	0.750	0.582	0.045
D3492-5	0.375	0.188	0.045
D3492-7	0.500	0.270	0.045



D3492-1/-3/-5/-7 PLUG NOTES

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6
 QQ-A-225/7 (5052) OR QQ-A-200/8 (6061) OR QQ-A-200/9 (6061)
 (REF. DART MATERIAL SPECIFICATION)
- FINISH: ACID ETCH AND ALODINE P
 POWDER COAT WHITE (4.35 MILS)
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED
- BREAK ALL SHARP CORNERS 0.010 MAX

WORK ORDER NO. **2776**

ADD -047; UPDATE DIM A, -045	REV. B
NEW ISSUE	SHEET 1 OF 1
DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	SCALE
DRAWING NO. D3492	NTS
TITLE PLUG	

